



3M Science.
Applied to Life.™

3M™ Roloc™ Application Guide

[START >>>](#)

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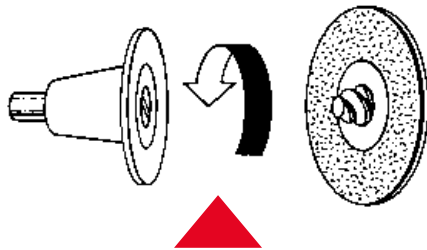
With the easy-to-use 3M™ Roloc™ Quick Release System, operators can select the 3M product most suited to the application. Changing products or grades is as simple as a quick twist-off, twist-on motion.

What is Roloc™?

The benefits of the Roloc™ attachment

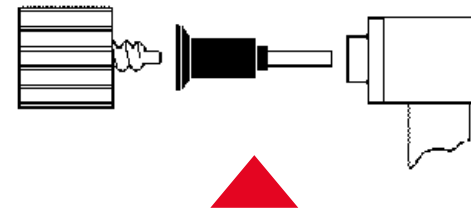
3M™ Roloc™ Abrasive Discs are smaller discs that quickly attach onto a Roloc™ disc pad so that you can conveniently and rapidly change discs as needed. Our system provides a secure attachment even for heavy-duty applications. Each disc is also color-coded to identify its grade, making it easy to select the grade required for different applications.

- ▶ Remote applications
- ▶ Retain extra control
- ▶ Localized, refining, finishing
- ▶ Corner or curved surfaces
- ▶ Intricate, difficult to reach areas
- ▶ Remove weld splatter on small areas



3M™ Roloc™ Quick Release System

- ▶ 3M™ Roloc™ discs are designed for use on the face of the disc
- ▶ Available in a range of products for grinding, finishing, deburring and cleaning applications
- ▶ The 3M™ Roloc™ Back-Up Pad assures secure fixing with rapid grade or product change
- ▶ Can be used with 3M™ Roloc™ Rubber Back-Up Pad




3M™ Roloc™+ Quick Release System

- ▶ 3M™ Roloc™+ discs/brushes are designed for use on the edge and have a longer shaft for extra strength
- ▶ Available in a range of products for finishing, deburring and cleaning applications
- ▶ The 3M™ Roloc™ plastic holder assures secure fixing with rapid grade or product change
- ▶ To be used with all 3M™ Roloc™+ plastic holders (excluding 3M™ Roloc™ rubber back-up pads)


3M™ Roloc™ Disc button color/grade chart

●	24+ grade/black
●	36+ grade/brown
●	50+ grade/green
●	60+ grade/orange
●	80+ grade/yellow
●	P100 grade/blue
○	P120 grade/white
●	P150 grade/black
●	P180 grade/brown
●	P240 grade/green
●	P320 grade/yellow
●	P400 grade/blue

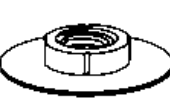
3M™ Roloc™ Attachment System Guide



▶ **TR** – plastic button



▶ **TSM** – metal button



▶ **TS** – plastic button

Diameter	Attachment type		
	TR	TSM	TS
3/4"	◆		◆
1"	◆	◆	◆
1-1/2"	◆	◆	◆
2"	◆	◆	◆
3"	◆	◆	◆
4"	◆		◆

Product ID	Attachment type		
	TR	TSM	TS
361F	◆	◆	
777F	◆	◆	◆
947A	◆	◆	
984F	◆	◆	
782C	◆	◆	
787C	◆	◆	
982C	◆	◆	
987C	◆	◆	

Optimum tool speeds to maximize 3M™ Roloc™ Disc cut rates and life

Disc size	Material			
	Stainless	Aluminum	Steel	Titanium
1-1/2"	20,000 RPM	30,000 RPM	30,000 RPM	9,000 RPM
2"	15,000 RPM	20,000 RPM	20,000 RPM	7,000 RPM
3"	10,000 RPM	15,000 RPM	15,000 RPM	4,500 RPM
4"	8,000 RPM	9,000 RPM	9,000 RPM	3,000 RPM

Meet the

Premium Series

of right angle abrasives **for unparalleled power and performance!**

Featuring 3M™ Cubitron™ II Abrasives for an unbeatable combination of speed and long life, and Scotch-Brite™ Abrasives for ease of use and consistent quality finishes.



Introducing the

Advanced Series

of right angle abrasives **for value-priced performance!**

The next-best thing to our Premium Series of 3M™ Cubitron™ II Abrasives, our new Advanced Series harnesses the power of 3M™ Precision-Shaped Ceramic Grain and helps minimize your abrasive spend.

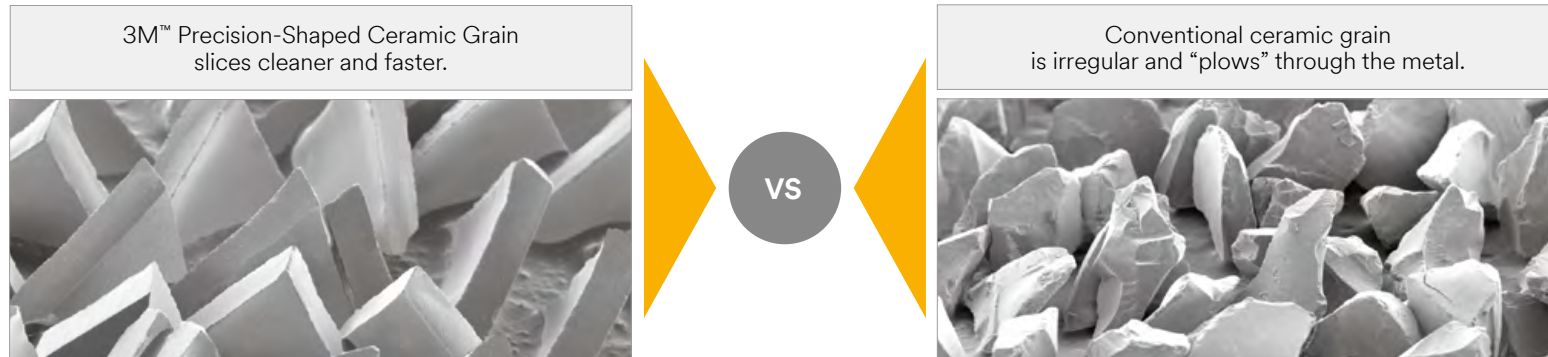


Technology:

CUBITRON™ II

3M™ Cubitron™ II Abrasives are revolutionizing the cutting and grinding process. They're faster-cutting and longer-lasting than conventional abrasives.

The secret lies in the revolutionary 3M™ Precision-Shaped Ceramic Grain technology. As the triangular-shaped grain wears, it continuously fractures to form sharp peaks that slice through metal – providing a cooler, faster and longer lasting cut.



- ✓ Cooler operation
- ✓ Clean cut
- ✓ Lasts much longer



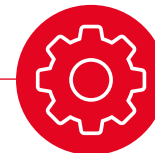
- ✗ Heat build-up
- ✗ Slower cutting
- ✗ Shorter life



Cuts faster



Works harder



Increases productivity

Technology:

Scotch-Brite™

The perfect finish starts with Scotch-Brite™

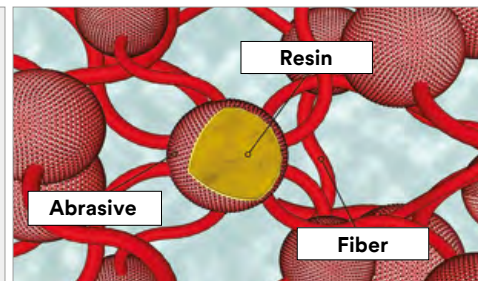
There's one family of abrasives that's trusted to deliver repeatable results and fine finishes, and it's Scotch-Brite. With roots in the past and an eye on the future, Scotch-Brite™ Industrial Abrasives are dedicated to uncompromising quality – just like you.

Scotch-Brite Non-Woven technology explained

Our unique non-woven web is the secret to superior performance. It binds together synthetic fibers and abrasive particles to create a conformable, three-dimensional material. Its open structure reduces the risk of warping or discoloring the part, resists loading, improves finish and prolongs the product's life.

What makes Scotch-Brite the best you can buy?

- ▶ A tough, non-woven nylon web impregnated with resin and mineral throughout its structure
- ▶ Spring-like action produces a smooth, burr-free surface
- ▶ Uniform, consistent results with no undercutting
- ▶ Suitable for deburring, finishing, cleaning and small weld removal applications
- ▶ Easy to use, less rework, fewer rejects



Application guide



Application use:

Premium Series

Designed for unparalleled power and performance

Color key for navigating product sections:

-  = Grinding and stock removal
-  = Deburring
-  = Refining and finishing
-  = Contamination removal and cleaning
-  = Roloc+ range

Products:	Page #	Substrate use:	Grinding & stock removal	Deburring	Refining	Finishing	Cleaning	Contaminate removal
 3M™ Cubitron™ II Roloc™ Disc 984F	13	mild steel, stainless steel	heavy	◆	◆	◆		
 3M™ Cubitron™ II Roloc™ Disc 947A	14	mild steel, stainless steel, aluminum	medium			◆		
 3M™ Cubitron™ II Roloc™ Fibre Disc 982C	15	mild steel	medium/high	◆	◆			
 3M™ Cubitron™ II Roloc™ Fibre Disc 987C	16	stainless steel, non-ferrous metals, aluminum	medium/high	◆	◆			
 Scotch-Brite™ Roloc™ Deburr & Finish Pro Unitized Wheel (DP-UW)	25	all metals		heavy		◆		
 Scotch-Brite™ Roloc™ EXL Unitized Wheel (DP-UR)	26	metals, plastics, composites		moderate/heavy		◆		
 Scotch-Brite™ Roloc™ Rapid Cut Unitized Wheel (RC-UR)	27	all metals		edge		◆		
 Scotch-Brite™ Roloc™ Anti-loading Surface Conditioning Disc (AL-DR)	30-31	aluminum, white metals				◆		
 Scotch-Brite™ Roloc™ Surface Conditioning Disc (SC-DR)	32-33	all metals		◆	◆	◆	◆	
 Scotch-Brite™ Roloc™ Light Grind and Blend Disc (GB-DR)	34	all metals		light		◆		
 Scotch-Brite™ Roloc™ Surface Conditioning Disc (SE-DR)	35	all metals		heavy	◆	◆	◆	
 Scotch-Brite™ Roloc™ Clean & Strip XT Pro Disc (XO-DR)	38	rust, coatings, weld discoloration					◆	heavy removal
 Scotch-Brite™ Roloc™ Clean & Strip XT Pro Extra Cut Disc (XC-DR)	39	heavy rust and rust pit removal without leaving divots			◆		◆	◆
 Scotch-Brite™ Roloc™ Bristle Disc (RD-ZB)	40	all metals		◆		◆	◆	
 Scotch-Brite™ Roloc+™ Flap Brush (FF-ZR/PF-ZR/CB-ZR)	42	wood, metals, lacquers		light			◆	
 Scotch-Brite™ Roloc+™ Cut and Polish Disc (C5/ZR)	42	all metals		light		◆	◆	
 Scotch-Brite™ Roloc+™ Clean & Strip XT Pro Extra Cut Disc	43	corrosion, coatings, metals			◆		◆	◆
 Scotch-Brite™ Roloc+™ Clean & Strip XT Pro Disc	43	corrosion, coatings, metals					◆	heavy removal

Advanced Series

Designed for value-priced performance

Products:	Page #	Substrate use:	Grinding & stock removal	Deburring	Refining	Finishing	Cleaning	Contaminate removal
 3M™ Roloc™ Fibre Disc 782C	17	mild steel	medium/high	◆	◆	◆		
 3M™ Roloc™ Fibre Disc 787C	18	stainless steel, non-ferrous metals, aluminum	medium/high	◆	◆	◆		
 3M™ Roloc™ Disc 777F	19-20	mild steel, stainless steel, non-ferrous metals, aluminum	medium			◆		
 3M™ Roloc™ Disc 361F	21-22	all metals			◆	◆	◆	◆

Application guide continued from previous page >>>

Application use:

Premium Series

Products:

Page

Substrate use:

Beveling

Weld prep

Weld removal

Blending




Rust removal

Paint prep

	3M™ Cubitron™ II Roloc™ Disc 984F	13	mild steel, stainless steel	◆	◆	small welds	◆		
	3M™ Cubitron™ II Roloc™ Disc 947A	14	mild steel, stainless steel, aluminum						
	3M™ Cubitron™ II Roloc™ Fibre Disc 982C	15	mild steel			small welds	◆		
	3M™ Cubitron™ II Roloc™ Fibre Disc 987C	16	stainless steel, non-ferrous metals, aluminum			small welds	◆		
	Scotch-Brite™ Roloc™ Deburr & Finish Pro Unitized Wheel (DP-UW)	25	all metals				◆		
	Scotch-Brite™ Roloc™ EXL Unitized Wheel (DP-UR)	26	metals, plastics, composites				weld blending		
	Scotch-Brite™ Roloc™ Rapid Cut Unitized Wheel (RC-UR)	27	all metals				weld blending		
	Scotch-Brite™ Roloc™ Anti-loading Surface Conditioning Disc (AL-DR)	30-31	aluminum, white metals				◆		
	Scotch-Brite™ Roloc™ Surface Conditioning Disc (SC-DR)	32-33	all metals				◆		◆
	Scotch-Brite™ Roloc™ Light Grind and Blend Disc (GB-DR)	34	all metals			small welds	◆		◆
	Scotch-Brite™ Roloc™ Surface Conditioning Disc (SE-DR)	35	all metals						
	Scotch-Brite™ Roloc™ Clean & Strip XT Pro Disc (XO-DR)	38	rust, coatings, weld discoloration					◆	◆
	Scotch-Brite™ Roloc™ Clean & Strip XT Pro Extra Cut Disc (XC-DR)	39	heavy rust and rust pit removal without leaving divots					◆	◆
	Scotch-Brite™ Roloc™ Bristle Disc (RD-ZB)	40	all metals				◆	◆	
	Scotch-Brite™ Roloc+™ Flap Brush (FF-ZR/PF-ZR/CB-ZR)	42	wood, metals, lacquers						
	Scotch-Brite™ Roloc+™ Cut and Polish Disc (C5/ZR)	42	all metals						
	Scotch-Brite™ Roloc+™ Clean & Strip XT Pro Extra Cut Disc	43	corrosion, coatings, metals						
	Scotch-Brite™ Roloc+™ Clean & Strip XT Pro Disc	43	corrosion, coatings, metals						

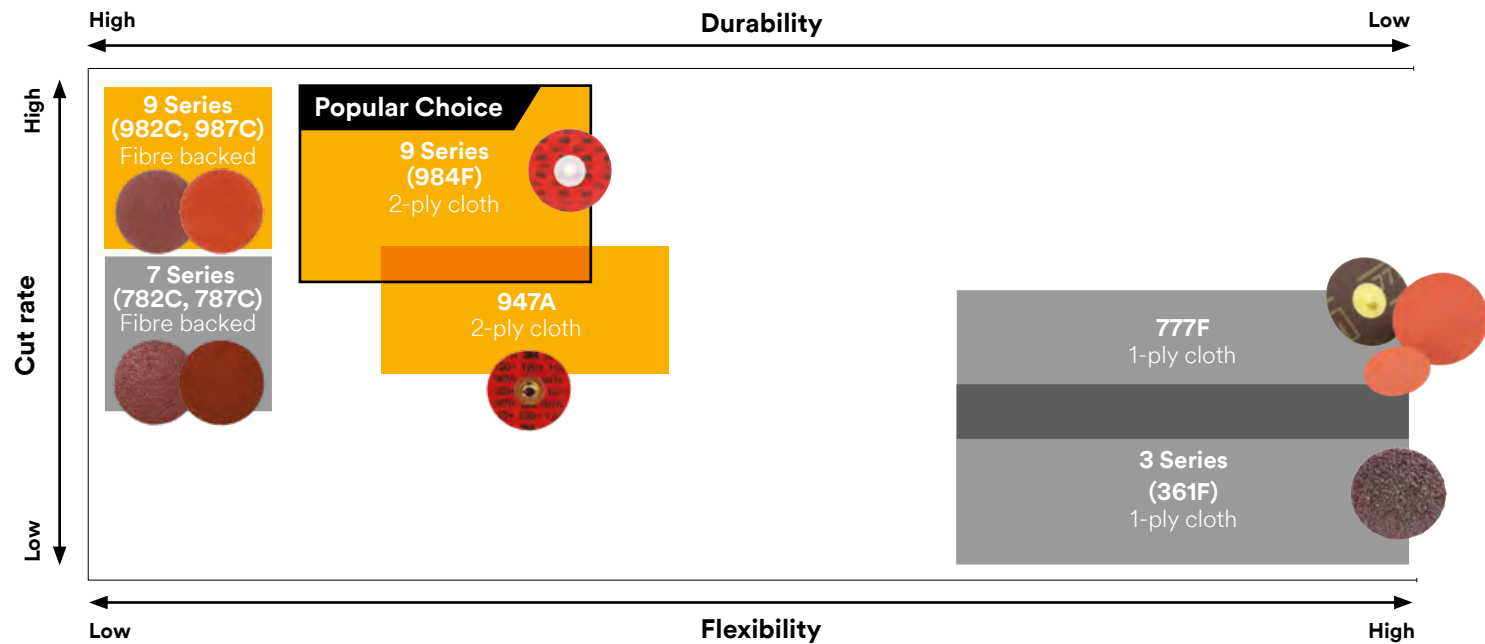
Advanced Series

Products:

	3M™ Roloc™ Fibre Disc 782C	17	mild steel			small welds	◆		
	3M™ Roloc™ Fibre Disc 787C	18	stainless steel, non-ferrous metals, aluminum			small welds	◆		
	3M™ Roloc™ Disc 777F	19-20	mild steel, stainless steel, non-ferrous metals, aluminum				◆		
	3M™ Roloc™ Disc 361F	21-22	all metals					◆	

Grinding and stock removal

Positioning | Grinding and stock removal



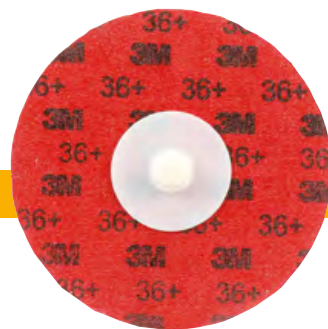
Please note: Back-up pad affects disc performance

Premium Series Products:

	Feature	Substrate	Application
3M™ Cubitron™ II Roloc™ Fibre Disc 982C	3M™ Precision-Shaped Ceramic Grain	Mild steel	Small weld removal, blending, refining, deburring, small beveling
3M™ Cubitron™ II Roloc™ Fibre Disc 987C	3M™ Precision-Shaped Ceramic Grain, grinding aid	Stainless steel, non-ferrous metals, aluminum	
3M™ Cubitron™ II Roloc™ Durable Edge Disc 984F	3M™ Precision-Shaped Ceramic Grain, durable edge, grinding aid	Mild steel, stainless steel	Beveling, weld prep, small weld removal, blending, finishing, refining, deburring
3M™ Cubitron™ II Roloc™ Durable Edge Disc 947A	3M™ Precision-Shaped Ceramic Grain blend, durable edge, grinding aid	Mild steel, stainless steel, aluminum	Works for lighter applications than 984F due to the blend of 3M™ Precision-Shaped Ceramic Grain and conventional grain

Advanced Series Products:


3M™ Roloc™ Fibre Disc 782C	3M™ Precision-Shaped Ceramic Grain	Mild steel	Small weld removal, blending, finishing, refining, deburring, small beveling
3M™ Roloc™ Fibre Disc 787C	3M™ Precision-Shaped Ceramic Grain, grinding aid	Stainless steel, non-ferrous metals, aluminum	
3M™ Roloc™ Disc 777F	Ceramic and aluminum oxide blend, grinding aid	Mild steel, stainless steel, non-ferrous metals, aluminum	Medium stock removal, grinding, blending
3M™ Roloc™ Disc 361F	Aluminum oxide, good grade range	All metals	General purpose applications, rust removal, cleaning, contaminate removal, finishing, refining




3M™ Cubitron™ II Roloc™ Disc 984F

Premium Series

for unparalleled power and performance

UPC	Diameter (inches)	Grade	Button color	Max. speed (RPM)	Min./case
Roloc™ TR (plastic button) 					
051141-27700-4	1-1/2"	36+	White	30,000	50/200
051141-27708-0	1-1/2"	60+	White	30,000	50/200
051141-27716-5	1-1/2"	80+	White	30,000	50/200
051141-27701-1	2"	36+	White	25,000	50/200
051141-27709-7	2"	60+	White	25,000	50/200
051141-27717-2	2"	80+	White	25,000	50/200
051141-27702-8	3"	36+	White	20,000	50/200
051141-27710-3	3"	60+	White	20,000	50/200
051141-28218-3	3"	80+	White	20,000	50/200
051141-27703-5	4"	36+	White	12,000	25/100
051141-27711-0	4"	60+	White	12,000	25/100
051141-27719-6	4"	80+	White	12,000	25/100

Roloc™ TSM (metal button) 					
051141-27704-2	1-1/2"	36+	Metal	30,000	50/200
051141-27712-7	1-1/2"	60+	Metal	30,000	50/200
051141-27720-2	1-1/2"	80+	Metal	30,000	50/200
051141-27705-9	2"	36+	Metal	25,000	50/200
051141-27713-4	2"	60+	Metal	25,000	50/200
051141-27721-9	2"	80+	Metal	25,000	50/200
051141-27706-6	3"	36+	Metal	20,000	50/200
051141-27714-1	3"	60+	Metal	20,000	50/200
051141-27707-3	4"	36+	Metal	12,000	25/100
051141-27715-8	4"	60+	Metal	12,000	25/100
051141-27723-3	4"	80+	Metal	12,000	25/100

Feature:

3M™ Precision-Shaped Ceramic Grain, durable edge, grinding aid

Backing:

Y weight polyester cloth, 2-ply cloth, durable edge

Application:

Medium/high stock removal, medium/low pressure

Substrate:

Mild steel, stainless steel



- ▶ 3M™ Cubitron™ II Roloc™ Disc 984F is made with revolutionary 3M precision-shaped grain technology
- ▶ For grinding, blending and deburring of light to medium pressure applications for virtually all metal types
- ▶ Disc life is significantly longer, allowing for completion of more parts per disc and requiring fewer disc changes
- ▶ The durable edge design also ensures edge wear is kept to a minimum



3M™ Cubitron™ II Roloc™ Disc 947A

Premium Series

for unparalleled power and performance

UPC	Diameter (inches)	Grade	Button color	Max. speed (RPM)	Min./case
Roloc™ TR (plastic button) 					
051141-54239-3	1-1/2"	40+	White	30,000	50/200
051141-54247-8	1-1/2"	60+	White	30,000	50/200
051141-54255-3	1-1/2"	80+	White	30,000	50/200
051141-54263-8	1-1/2"	120+	White	30,000	50/200
051141-54240-9	2"	40+	White	25,000	50/200
051141-54248-5	2"	60+	White	25,000	50/200
051141-54256-0	2"	80+	White	25,000	50/200
051141-54264-5	2"	120+	White	25,000	50/200
051141-54241-6	3"	40+	White	20,000	50/200
051141-54249-2	3"	60+	White	20,000	50/200
051141-54257-7	3"	80+	White	20,000	50/200
051141-54265-2	3"	120+	White	20,000	50/200
051141-54242-3	4"	40+	White	12,000	25/100
051141-54250-8	4"	60+	White	12,000	25/100
051141-54258-4	4"	80+	White	12,000	25/100
051141-54266-9	4"	120+	White	12,000	25/100
Roloc™ TSM (metal button) 					
051141-54243-0	1-1/2"	40+	Metal	30,000	50/200
051141-54251-5	1-1/2"	60+	Metal	30,000	50/200
051141-54259-1	1-1/2"	80+	Metal	30,000	50/200
051141-54267-6	1-1/2"	120+	Metal	30,000	50/200
051141-54244-7	2"	40+	Metal	25,000	50/200
051141-54252-2	2"	60+	Metal	25,000	50/200
051141-54260-7	2"	80+	Metal	25,000	50/200
051141-54268-3	2"	120+	Metal	25,000	50/200
051141-54245-4	3"	40+	Metal	20,000	50/200
051141-54253-9	3"	60+	Metal	20,000	50/200
051141-54261-4	3"	80+	Metal	20,000	50/200
051141-54269-0	3"	120+	Metal	20,000	50/200
051141-54246-1	4"	40+	Metal	12,000	25/100
051141-54254-6	4"	60+	Metal	12,000	25/100
051141-54262-1	4"	80+	Metal	12,000	25/100
051141-54270-6	4"	120+	Metal	12,000	25/100

Feature:

3M™ Precision-Shaped Ceramic Grain blend, durable edge, grinding aid

Backing:

X weight poly-cotton cloth, 2-ply cloth, durable edge

Application:

Medium stock removal, medium pressure

Substrate:

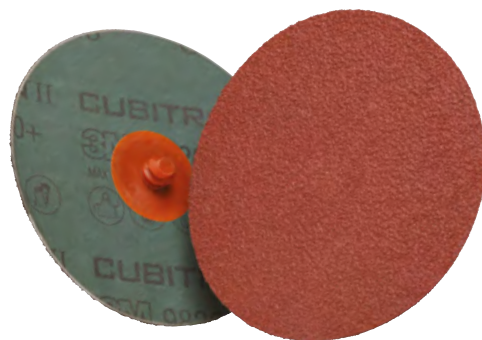
Mild steel, stainless steel, aluminum

- ▶ 3M™ Cubitron™ II Roloc™ Disc 947A uses proprietary precision-shaped ceramic grain to produce exceptionally fast cut rates
- ▶ Great for deburring, blending, cleaning, and finishing applications
- ▶ Loading resistant resulting in a faster cut and longer lasting disc

3M™ Cubitron™ II Roloc™ Disc 982C

Premium Series

for unparalleled power and performance






Feature:
3M™ Precision-Shaped Ceramic Grain

Backing:
Rigid fibre backing

Application:
Heavy stock removal, heavy/medium pressure

Substrate:
Mild steel

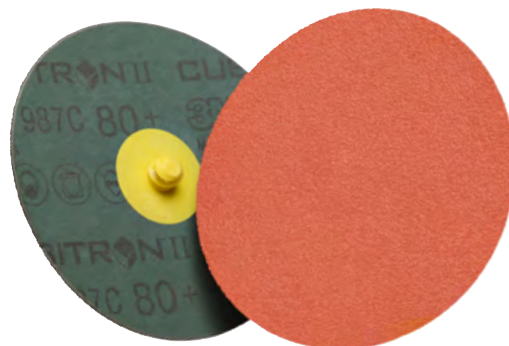
UPC	Diameter (inches)	Grade	Button color	Max. speed (RPM)	Min./case
Roloc™ TR (plastic button) 					
051115-66778-7	2"	36+	Brown	25,000	50/200
051115-66783-1	2"	60+	Orange	25,000	50/200
051115-66788-6	2"	80+	Yellow	25,000	50/200
051115-66779-4	3"	36+	Brown	20,000	50/200
051115-66784-8	3"	60+	Orange	20,000	50/200
051115-66789-3	3"	80+	Yellow	20,000	50/200
051115-66780-0	4"	36+	Brown	12,000	25/100
051115-66785-5	4"	60+	Orange	12,000	25/100
051115-66790-9	4"	80+	Yellow	12,000	25/100
Roloc™ TSM (metal button) 					
051115-66781-7	2"	36+	Metal	25,000	50/200
051115-66786-2	2"	60+	Metal	25,000	50/200
051115-66791-6	2"	80+	Metal	25,000	50/200
051115-66782-4	3"	36+	Metal	20,000	50/200
051115-66787-9	3"	60+	Metal	20,000	50/200
051115-66792-3	3"	80+	Metal	20,000	50/200
Roloc™ TS (plastic button) 					
051125-86755-9	4"	36+	Brown	12,000	25/100
051125-86760-3	4"	60+	Orange	12,000	25/100
051125-86761-0	4"	80+	Yellow	12,000	25/100

- ▶ 3M™ Cubitron™ II Roloc™ Fibre Disc 982C features 3M precision-shaped grain technology and a rigid fibre backing, for a combination of long life and fast, aggressive cut
- ▶ Cuts faster, requires less grinding pressure and lasts up to twice as long as conventional ceramic abrasives
- ▶ Excellent for edge chamfering, beveling, blending and removing carbon steel welds, mill scale, machining grooves and more

3M™ Cubitron™ II Roloc™ Disc 987C

Premium Series

for unparalleled power and performance





Feature:
3M™ Precision-Shaped Ceramic Grain, grinding aid

Backing:
Rigid fibre backing

Application:
Weld prep, weld removal

Substrate:
Stainless steel and other heat-sensitive alloys

UPC	Diameter (inches)	Grade	Button color	Max. speed (RPM)	Min./case
Roloc™ TR (plastic button) 					
051125-94952-1	2"	36+	Brown	25,000	50/200
051125-94957-6	2"	60+	Orange	25,000	50/200
051125-94962-0	2"	80+	Yellow	25,000	50/200
051125-94953-8	3"	36+	Brown	20,000	50/200
051125-94958-3	3"	60+	Orange	20,000	50/200
051125-94963-7	3"	80+	Yellow	20,000	50/200
051125-94954-5	4"	36+	Brown	12,000	25/100
051125-94959-0	4"	60+	Orange	12,000	25/100
051125-94964-4	4"	80+	Yellow	12,000	25/100
Roloc™ TSM (metal button) 					
051125-94955-2	2"	36+	Metal	25,000	50/200
051125-94960-6	2"	60+	Metal	25,000	50/200
051125-94965-1	2"	80+	Metal	25,000	50/200
051125-94956-9	3"	36+	Metal	20,000	50/200
051125-94961-3	3"	60+	Metal	20,000	50/200
051125-94966-8	3"	80+	Metal	20,000	50/200

- ▶ Best-in-class for weld prep and removal, 3M™ Cubitron™ II Roloc™ Fibre Disc 987C features 3M precision-shaped grain technology for an ultra-rapid cut
- ▶ 3M precision-shaped ceramic grain has ultra-sharp, fast-cutting points that wear evenly, run cool and optimize mineral breakdown to maximize life
- ▶ Excellent choice for weld removal, blending and finish refinement on stainless steel and high nickel alloys

3M™ Roloc™ Fibre Disc 782C

Advanced Series

for value-priced performance



Feature:

3M™ Precision-Shaped Ceramic Grain

Backing:



Fibre backing

Application:

Medium/high stock removal, medium/low pressure

Substrate:

Mild steel

UPC	Diameter (inches)	Grade	Button color	Max. speed (RPM)	Min./case
Roloc™ TR (plastic button) 					
076308-89665-2	2"	36+	Brown	25,000	50/200
076308-89670-6	2"	60+	Orange	25,000	50/200
076308-89675-1	2"	80+	Yellow	25,000	50/200
076308-89666-9	3"	36+	Brown	20,000	50/200
076308-89671-3	3"	60+	Orange	20,000	50/200
076308-89676-8	3"	80+	Yellow	20,000	50/200
076308-89667-6	4"	36+	Brown	12,000	25/100
076308-89672-0	4"	60+	Orange	12,000	25/100
076308-89677-5	4"	80+	Yellow	12,000	25/100
Roloc™ TS (plastic button) 					
076308-89685-0	4"	36+	Brown	12,000	25/100
076308-89686-7	4"	60+	Orange	12,000	25/100
076308-89687-4	4"	80+	Yellow	12,000	25/100

- ▶ 3M™ Roloc™ Fibre Disc 782C features precision-shaped ceramic grain
- ▶ With its outstanding cut, durability and ease of use, this disc offers a major step up in performance over conventional fibre discs
- ▶ Advanced abrasive technology makes it an excellent choice for tough applications including weld removal, blending and finish refinement

3M™ Roloc™ Fibre Disc 787C

Advanced Series

for value-priced performance





Feature:
3M™ Precision-Shaped Ceramic Grain, grinding aid

Backing:
Fibre backing

Application:
Medium/high stock removal, medium/low pressure

Substrate:
Stainless steel, non-ferrous metals, aluminum

UPC	Diameter (inches)	Grade	Button color	Max. speed (RPM)	Min./case
Roloc™ TR (plastic button) 					
076308-89689-8	2"	36+	Brown	25,000	50/200
076308-89694-2	2"	60+	Orange	25,000	50/200
076308-89699-7	2"	80+	Yellow	25,000	50/200
076308-89704-8	2"	120+	White	25,000	50/200
076308-89690-4	3"	36+	Brown	20,000	50/200
076308-89695-9	3"	60+	Orange	20,000	50/200
076308-89700-0	3"	80+	Yellow	20,000	50/200
076308-89705-5	3"	120+	White	20,000	50/200
076308-89691-1	4"	36+	Brown	12,000	25/100
076308-89696-6	4"	60+	Orange	12,000	25/100
076308-89701-7	4"	80+	Yellow	12,000	25/100
076308-89706-2	4"	120+	White	12,000	25/100
Roloc™ TS (Plastic Button) 					
076308-89709-3	4"	36+	Brown	12,000	25/100
076308-89710-9	4"	60+	Orange	12,000	25/100
076308-89711-6	4"	80+	Yellow	12,000	25/100
076308-89712-3	4"	120+	White	12,000	25/100


- ▶ Engineered for ultra-rapid cut, 3M™ Roloc™ Fibre Disc 787C features precision-shaped ceramic grain
- ▶ Cuts cooler, faster and lasts longer than alumina zirconia (AZ) and conventional ceramic discs in applications like weld removal, beveling, edge chamfering and more
- ▶ Constructed with a grinding aid, it is an excellent choice for weld removal, blending and finish refinement on stainless steel and high nickel alloys

3M™ Roloc™ Disc 777F

Advanced Series

for value-priced performance



UPC	Diameter (inches)	Grade	Button color	Max. speed (RPM)	Min./case
Roloc™ TR (plastic button) 					
051144-76622-2	1"	36	Brown	30,000	50/500
051144-76623-9	1"	50	Green	30,000	50/500
051144-76624-6	1"	60	Orange	30,000	50/500
051144-76625-3	1"	80	Yellow	30,000	50/500
638060-70794-4	1"	P100	Blue	30,000	50/500
051144-80510-5	1"	P120	White	30,000	50/500
051119-57828-7	1"	P150	Black	30,000	50/500
051119-40434-0	1"	P180	Brown	30,000	50/500
051144-76627-7	1-1/2"	50	Green	30,000	50/500
051144-76628-4	1-1/2"	60	Orange	30,000	50/500
051144-14660-4	1-1/2"	80	Yellow	30,000	50/500
051144-80511-2	1-1/2"	P120	White	30,000	50/500
051144-76629-1	2"	36	Brown	25,000	50/200
051144-76630-7	2"	50	Green	25,000	50/200
051144-76433-4	2"	60	Orange	25,000	50/200
051144-14661-1	2"	80	Yellow	25,000	50/200
051144-80508-2	2"	P100	Blue	25,000	50/200
051144-80512-9	2"	P120	White	25,000	50/200
051144-83469-3	2"	P150	Black	25,000	50/200
051144-76631-4	3"	36	Brown	20,000	50/200
051144-76632-1	3"	50	Green	20,000	50/200
051144-76633-8	3"	60	Orange	20,000	50/200
051144-76634-5	3"	80	Yellow	20,000	50/200
051144-80509-9	3"	P100	Blue	20,000	50/200
051144-80513-6	3"	P120	White	20,000	50/200
051119-16295-0	3"	P150	Black	20,000	50/200
051125-40045-9	3"	P180	Brown	20,000	50/200

Feature:
Ceramic and aluminum oxide blend, grinding aid

Backing:
Y weight polyester cloth

Application:
Medium stock removal, medium pressure

Substrate:
Mild steel, stainless steel, non-ferrous metals, aluminum

- ▶ 3M™ Roloc™ Disc 777F ensures a fast and consistent cut rate for all types of medium-pressure grinding and blending applications
- ▶ Grinding aid reduces grinding temperatures for processes involving heat-sensitive alloys such as stainless steel, nickel alloys and titanium

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3M™ Roloc™ Disc 777F

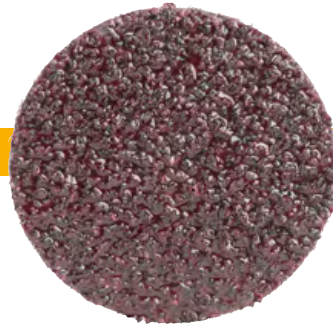
Advanced Series

for value-priced performance



CHART CONTINUED (from previous page)


UPC	Diameter (inches)	Grade	Button color	Max. speed (RPM)	Min./case
Roloc™ TSM (metal button) 					
051111-49949-8	2"	36	Metal	25,000	50/200
051111-50253-2	2"	60	Metal	25,000	50/200
051111-50254-9	2"	80	Metal	25,000	50/200
051111-50255-6	2"	P100	Metal	25,000	50/200
051111-50256-3	2"	P120	Metal	25,000	50/200
051119-19462-3	2"	P180	Metal	25,000	50/200
051111-50257-0	3"	36	Metal	20,000	50/200
051111-50257-0	3"	60	Metal	30,000	50/500
051111-50257-0	3"	80	Metal	30,000	50/2500
051111-50257-0	3"	P120	Metal	25,000	50/200
Roloc™ TS (plastic button) 					
051144-76742-7	2"	36	Brown	25,000	50/200
051144-76746-5	2"	50	Green	25,000	50/200
051144-76750-2	2"	60	Orange	25,000	50/200
051144-76754-0	2"	80	Yellow	25,000	50/200
051119-84478-8	2"	P100	Blue	25,000	50/500
051125-19363-4	2"	P120	White	25,000	50/500
051144-76743-4	3"	36	Brown	20,000	50/200
051144-76747-2	3"	50	Green	20,000	50/200
051144-76751-9	3"	60	Orange	20,000	50/200
051144-76755-7	3"	80	Yellow	20,000	50/200
051125-39547-2	3"	P100	Blue	20,000	50/200
051125-21811-5	3"	P120	White	20,000	50/200



3M™ Roloc™ Disc 361F

Advanced Series

for value-priced performance

UPC	Diameter (inches)	Grade	Button color	Max. speed (RPM)	Min./case
Roloc™ TR (plastic button) 					
638060-70450-9	1"	24	Black	30,000	50/500
051144-11412-2	1"	36	Brown	30,000	50/500
051144-11411-5	1"	50	Green	30,000	50/500
051144-11417-7	1"	60	Orange	30,000	50/500
051144-11416-0	1"	80	Yellow	30,000	50/500
051144-11415-3	1"	P100	Blue	30,000	50/500
051144-11414-6	1"	P120	White	30,000	50/500
638060-70469-1	1"	P180	Brown	30,000	50/500
051125-51966-3	1"	P240	Green	30,000	50/500
051144-11452-8*	1-1/2"	24	Black	30,000	50/500
051144-22396-1	1-1/2"	36	Brown	30,000	50/500
051144-11137-4	1-1/2"	50	Green	30,000	50/500
051144-22397-8	1-1/2"	60	Orange	30,000	50/500
051144-22407-4	1-1/2"	80	Yellow	30,000	50/500
051144-22408-1	1-1/2"	P100	Blue	30,000	50/500
051144-22409-8	1-1/2"	P120	White	30,000	50/500
051119-26865-2	1-1/2"	P150	Black	30,000	50/500
051144-11000-1	2"	24	Black	25,000	50/200
051144-22398-5	2"	36	Brown	25,000	50/200
051144-22399-2	2"	50	Green	25,000	50/200
051144-22400-5	2"	60	Orange	25,000	50/200
051144-22401-2	2"	80	Yellow	25,000	50/200
051144-22402-9	2"	P100	Blue	25,000	50/200
051144-22403-6	2"	P120	White	25,000	50/200
051144-14559-1	2"	P150	Black	25,000	50/200
051144-13873-9	2"	P180	Brown	25,000	50/200
051144-11419-1	2"	P240	Green	25,000	50/200
638060-70395-3	2"	P320	Yellow	25,000	50/200
051119-10141-6	2"	P400	Blue	25,000	50/200

Roloc™ TR (plastic button)

CHART CONTINUES (on next page)

Feature:
Aluminum oxide

Backing:
Y weight polyester cloth

Application:
Low pressure

Substrate:
All metal


- ▶ 3M™ Roloc™ Disc 361F uses an aluminum oxide grain and a flexible cloth backing to ensure a strong all-round performance on most metal surfaces
- ▶ General purpose grinding, blending and finishing on all metals

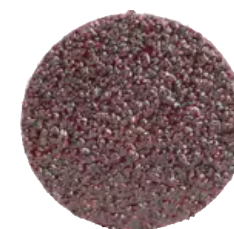
3M™ Roloc™ Disc 361F


Advanced Series

for value-priced performance

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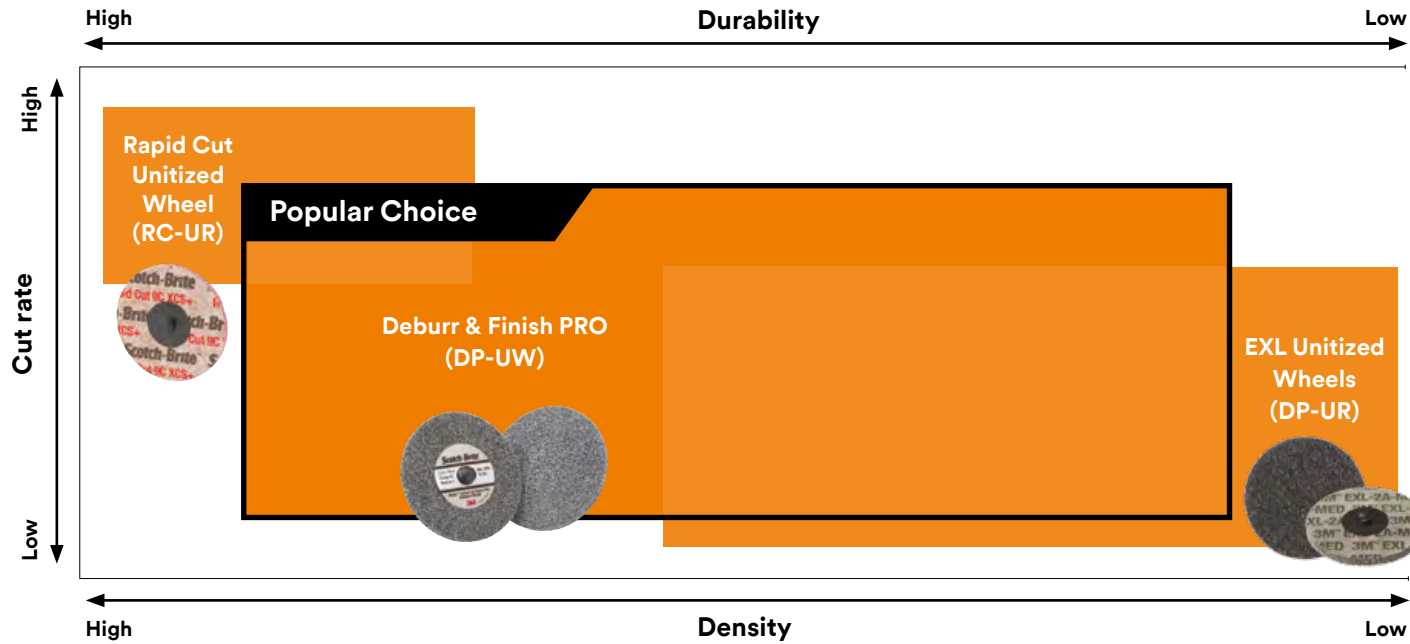
UPC	Diameter (inches)	Grade	Button color	Max. speed (RPM)	Min./case
Roloc™ TR (plastic button)  (continued)					
051144-22392-3	3"	24	Black	20,000	50/200
051144-22393-0	3"	36	Brown	20,000	50/200
051144-22394-7	3"	50	Green	20,000	50/200
051144-22395-4	3"	60	Orange	20,000	50/200
051144-22404-3	3"	80	Yellow	20,000	50/200
051144-22405-0	3"	P100	Blue	20,000	50/200
051144-22406-7	3"	P120	White	20,000	50/200
051144-82244-7	3"	P150	Black	20,000	50/200
051144-11418-4	3"	P240	Green	20,000	50/200
051144-77262-9	3"	P320	Yellow	20,000	50/200
051119-26730-3	4"	24	Black	12,000	25/100
051144-76429-7	4"	36	Brown	12,000	25/100
051144-11421-4	4"	60	Orange	12,000	25/100
051144-11420-7	4"	80	Yellow	12,000	25/100



Roloc™ TSM (metal button) 					
051111-49932-0	1-1/2"	36	Metal	30,000	50/500
051144-49933-7	1-1/2"	60	Metal	30,000	50/500
051144-49934-4	1-1/2"	80	Metal	30,000	50/500
051144-51039-1	1-1/2"	P100	Metal	30,000	50/500
051144-51038-4	1-1/2"	P120	Metal	30,000	50/500
051144-49936-8	2"	36	Metal	25,000	50/200
051144-49937-5	2"	60	Metal	25,000	50/200
051144-49938-2	2"	80	Metal	25,000	50/200
051144-51034-6	2"	P100	Metal	25,000	50/200
051144-49939-9	2"	P120	Metal	25,000	50/200
051144-51033-9	3"	36	Metal	20,000	50/200
051144-49940-5	3"	60	Metal	20,000	50/200
051144-49941-2	3"	80	Metal	20,000	50/200
051144-49942-9	3"	P100	Metal	20,000	50/200
051144-49943-6	3"	P120	Metal	20,000	50/200

Deburring

Positioning | Deburring



Product	Feature	Substrate	Application
Scotch-Brite™ Roloc™ Rapid Cut Unitized Wheel (RC-UR)	3M™ Precision-Shaped Ceramic Grain, consistent finish	All metals	Heavy deburring, weld blending
Scotch-Brite™ Roloc™ Deburr & Finish PRO Unitized Wheel (DP-UW)	Blend of 3M™ Precision-Shaped Ceramic Grain* and conventional grain, faster cut, longer disc life	All metals	Moderate to heavy deburring, finishing, blending
Scotch-Brite™ Roloc™ EXL Unitized Wheel (DP-UR)	Varying density for application (soft for conformability, hard for workpiece shape retention), used on edge or face without adjustment	Metals, plastics, composites	Edge deburring, finishing

*Grade 2S FIN contains only conventional grain


Scotch-Brite™ Roloc™ Deburr & Finish PRO Unitized Wheel (DP-UW)



Feature:
3M™ Precision-Shaped Ceramic Grain, low density

Application:
Deburring and finishing

Substrate:
All metals

UPC	Size (dia. x thk. x ctr. hole)	Grade	Max. speed (RPM)	Qty./case
Roloc™ TR (plastic button) 				
076308-77231-4	2" x 1/4" x NH	2S FIN	22,100	60
076308-77233-8	3" x 1/4" x NH	2S FIN	15,100	40
076308-77115-7	2" x 1/4" x NH	4C MED+	22,100	60
048011-65081-4	2" x 1/8" x NH	6C MED+	22,100	120
048011-65082-1	2" x 1/4" x NH	6C MED+	22,100	60
076308-77116-4	3" x 1/4" x NH	4C MED+	15,100	40
048011-65084-5	3" x 1/8" x NH	6C MED+	15,100	40
048011-65083-8	3" x 1/4" x NH	6C MED+	15,100	40
076308-77198-0	2" x 1/4" x NH	8C CRS+	22,100	60
076308-77197-3	3" x 1/8" x NH	8C CRS+	15,100	40
076308-77199-7	3" x 1/4" x NH	8C CRS+	15,100	40

- ▶ Scotch-Brite™ Roloc™ Deburr & Finish PRO Unitized Wheel is ideal for both OE use and for maintenance operations
- ▶ Soft to reduce defects, yet wears like iron, for fewer wheel changeouts
- ▶ Faster burr removal and better finish


Scotch-Brite™ Roloc™ EXL Unitized Wheel (DP-UR)



Feature:
Varying density for application, used on edge or face without adjustment

Application:
Deburring and weld blending (finishing)

Substrate:
Metals, plastics, composites

UPC	Diameter (inches)	Grade	Disc color	Max. speed (RPM)	Min./case
Roloc™ TR (plastic button) 					
048011-17185-2	2"	2A MED	Gray	22,100	15/60
048011-17183-8	2"	2S FIN	Gray	22,100	15/60
048011-17190-6	2"	6A MED	Tan	22,100	15/60
048011-17192-0	2"	8A MED	Tan	22,100	15/60
048011-17186-9	3"	2A MED	Gray	15,100	10/40
048011-17184-5	3"	2S FIN	Gray	15,100	10/40
048011-17191-3	3"	6A MED	Tan	15,100	10/40
048011-17193-7	3"	8A MED	Tan	15,100	10/40

- ▶ Manufactured with compressed, non-woven fiber construction and uniform grain distribution, our EXL Unitized Wheel produces consistent, professional results
- ▶ Hard densities offer good edge retention, which helps maintain consistent shape and cutting action
- ▶ Soft densities offer conformability and flexibility for finishing flat, contoured or irregular surfaces without damaging the part
- ▶ Compressed, open-web construction and uniform grain distribution provide consistent cutting action



Scotch-Brite™ Roloc™ Rapid Cut Unitized Wheels (RC-UR)



Feature:
3M™ Precision-Shaped Ceramic Grain, consistent finish

Application:
Deburring and weld blending (finishing)

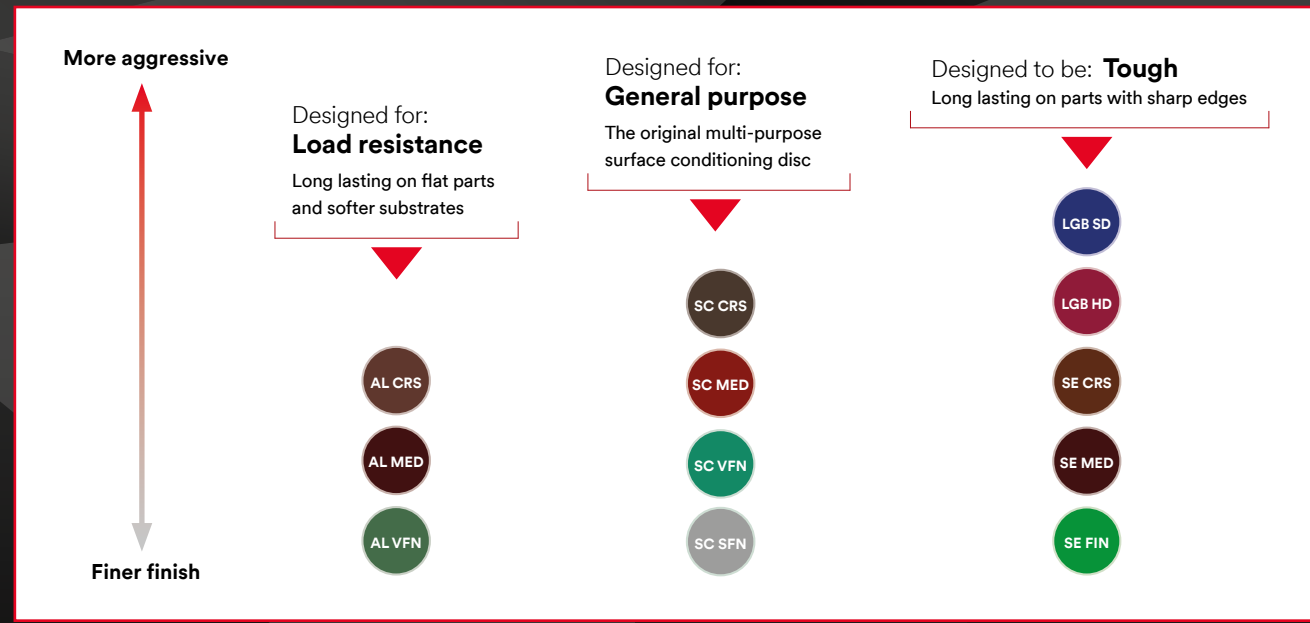
Substrate:
All metals

UPC	Size (dia. x ctr. hole)	Grade	Max. speed (RPM)	Min./case
Roloc™ TR (Plastic Button) 				
051115-66759-6	2" x NH	9C CRS+	22,100	15/60
048011-64859-0	3" x NH	9C CRS+	15,100	10/40
051115-66760-2	3" x NH	9C XCS+	15,100	10/40
Roloc™ TS (Plastic Button) 				
051115-66763-3	2" x NH	9C CRS+	22,100	15/60
051115-66764-0	3" x NH	9C XCS+	15,100	10/40

- ▶ Scotch-Brite™ Roloc™ Rapid Cut Unitized Wheels utilize 3M precision-shaped ceramic grain for higher levels of cut while maintaining a consistent finish
- ▶ Recommended for deburring and weld blending on all metals

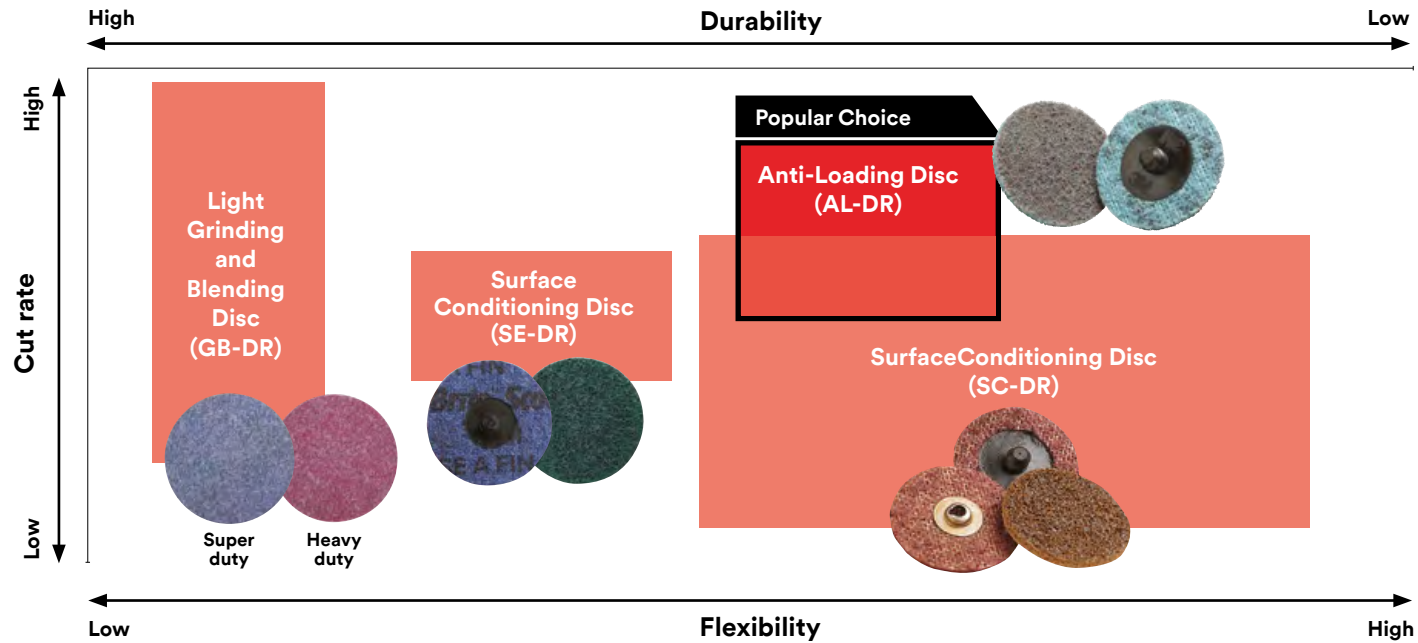
Scotch-Brite™ Surface Conditioning Disc Guide

Choose the right disc for the job.



Refining and finishing



Positioning | Refining and finishing



Product	Feature	Substrate	Application
Scotch-Brite™ Roloc™ Light Grinding and Blending Disc (GB-DR)	Ceramic and aluminum oxide blend, durable edge, heat resistant product construction, aggressive cut	All metals	Light grinding/metal stock removal, small weld removal, blending/deburring, paint prep, finishing
Scotch-Brite™ Roloc™ Surface Conditioning Disc (SE-DR)	Aluminum oxide, tough non-woven construction, strong edge, blue backing	All metals	Tough, non-woven construction for heavy deburring and finishing
Scotch-Brite™ Roloc™ Anti-Loading Surface Conditioning Disc (AL-DR)	Aluminum oxide, loftier construction to resist loading, long life in low pressure	Aluminum and softer metals	Blending, finishing
Scotch-Brite™ Roloc™ Surface Conditioning Disc (SC-DR)	Aluminum oxide, does not change the work piece geometry	Mild steel, stainless steel	Blending, refining, finishing, paint prep

Scotch-Brite™ Roloc™ Anti-Loading Surface Conditioning Disc (AL-DR)



UPC	Size dia. (inches) x cnt. hole	Grade	Disc color	Max. speed (RPM)	Min./case
Roloc™ TR (plastic button) 					
051141-54141-9	3/4" x NH	A CRS	Brown	30,000	200/cs
051141-54125-9	1" x NH	A CRS	Brown	30,000	200/cs
051141-54124-2	1" x NH	A MED	Maroon	30,000	200/cs
051141-54123-5	1" x NH	A VFN	Blue	30,000	200/cs
051141-54108-2	1-1/2" x NH	A CRS	Brown	30,000	200/cs
051141-54109-9	1-1/2" x NH	A MED	Maroon	30,000	200/cs
051141-54110-5	1-1/2" x NH	A VFN	Blue	30,000	200/cs
051141-54137-2	2" x NH	A CRS	Brown	25,000	50/200
051141-54136-5	2" x NH	A MED	Maroon	25,000	50/200
051141-54135-8	2" x NH	A VFN	Blue	25,000	50/200
051141-54140-2	3" x NH	A CRS	Brown	18,000	25/100
051141-54139-6	3" x NH	A MED	Maroon	18,000	25/100
051141-54138-9	3" x NH	A VFN	Blue	18,000	25/100
051141-54113-6	4" x NH	A CRS	Brown	12,000	25/100
051141-54112-9	4" x NH	A MED	Maroon	12,000	25/100
Roloc™ TSM (metal button) 					
051141-54149-5	1-1/2" x NH	A CRS	Metal	30,000	200/cs
051141-54148-8	1-1/2" x NH	A MED	Metal	30,000	200/cs
051141-54147-1	1-1/2" x NH	A VFN	Metal	30,000	200/cs
051141-54143-3	2" x NH	A CRS	Metal	25,000	50/200
051141-54142-6	2" x NH	A MED	Metal	30,000	50/200
051141-54146-4	2" x NH	A VFN	Metal	25,000	50/200
051141-54145-7	3" x NH	A CRS	Metal	18,000	25/100
051141-54144-0	3" x NH	A MED	Metal	18,000	25/100

Feature:
Aluminum oxide, loftier construction to resist loading, long life in low pressure

Backing:
Non-woven construction

Application:
Blending and finishing

Substrate:
Aluminum and softer metals

- ▶ Scotch-Brite™ Roloc™ AL Surface Conditioning Disc strikes the perfect balance between strength and softness
- ▶ Open web construction responds to surface irregularities and contours, while maintaining part geometry
- ▶ Non-woven nylon fibers break down gradually to expose fresh mineral, resulting in consistent cutting action
- ▶ Aluminum oxide mineral cuts sharp but finishes fine

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Scotch-Brite™ Roloc™ Anti-Loading Surface Conditioning Disc (AL-DR)

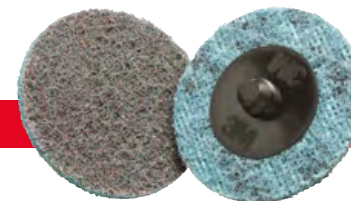



CHART CONTINUED (from previous page)

UPC	Size dia. (inches) x cnt. hole	Grade	Disc color	Max. speed (RPM)	Min./case
Roloc™ TS (plastic button) 					
051141-54114-3	2" x NH	A CRS	Brown	25,000	50/200
051141-54115-0	2" x NH	A MED	Maroon	25,000	50/200
051141-54116-7	2" x NH	A VFN	Blue	25,000	50/200
051141-54117-4	3" x NH	A CRS	Brown	18,000	25/100
051141-54118-1	3" x NH	A MED	Maroon	18,000	25/100
051141-54119-8	3" x NH	A VFN	Blue	18,000	25/100
051141-54150-1	3" x NH	A VFN	Blue	18,000	25/100
051141-54120-4	4" x NH	A CRS	Brown	12,000	25/100
051141-54121-1	4" x NH	A MED	Maroon	12,000	25/100

Scotch-Brite™ Roloc™ Surface Conditioning Disc (SC-DR)




UPC	Diameter (inches)	Grade	Disc color	Max. speed (RPM)	Min./case
Roloc™ TR (plastic button) 					
048011-15393-3	1"	A CRS	Brown	30,000	200/cs
048011-15392-6	1"	A MED	Maroon	30,000	200/cs
048011-15391-9	1"	A VFN	Blue	30,000	200/cs
048011-15568-5	1"	S SFN	Gray	30,000	200/cs
048011-08765-8	1-1/2"	A MED	Maroon	30,000	50/200
048011-08766-5	1-1/2"	A VFN	Blue	30,000	50/200
048011-08767-2	1-1/2"	S SFN	Gray	30,000	50/200
048011-05528-2	2"	A CRS	Brown	25,000	50/200
048011-05527-5	2"	A MED	Maroon	25,000	50/200
048011-05523-7	2"	A VFN	Blue	25,000	50/200
048011-05522-0	2"	S SFN	Gray	25,000	50/200
048011-05532-9	3"	A CRS	Brown	18,000	25/100
048011-05531-2	3"	A MED	Maroon	18,000	25/100
048011-05530-5	3"	A VFN	Blue	18,000	25/100
048011-05529-9	3"	S SFN	Gray	18,000	25/100
048011-12954-9	4"	A CRS	Brown	12,000	25/100
048011-12953-2	4"	A MED	Maroon	12,000	25/100
048011-12952-5	4"	A VFN	Blue	12,000	25/100
048011-12951-8	4"	S SFN	Gray	12,000	25/100
Roloc™ TSM (metal button) 					
048011-13249-5	1-1/2"	A CRS	Metal	30,000	50/200
048011-25775-4	1-1/2"	A CRS	Metal	30,000	50/200
048011-25774-7	1-1/2"	A MED	Metal	30,000	50/200
048011-25773-0	1-1/2"	A VFN	Metal	30,000	50/200
048011-25765-5	2"	A CRS	Metal	25,000	50/200
048011-25764-8	2"	A MED	Metal	25,000	50/200
048011-25770-9	2"	A VFN	Metal	25,000	50/200
048011-25767-9	3"	A CRS	Metal	18,000	25/100
048011-25766-2	3"	A MED	Metal	18,000	25/100
048011-25780-8	3"	A VFN	Metal	18,000	25/100
048011-13260-0	3"	S SFN	Metal	18,000	25/100
048011-25781-5	3"	S SFN	Metal	18,000	25/100

CHART CONTINUES (on next page)

Feature:
Aluminum oxide, maintains the work piece geometry

Backing:
Non-woven construction

Application:
Deburring, blending, finishing, cleaning


Substrate:
All metals

- ▶ The Scotch-Brite™ Roloc™ Surface Conditioning Disc combines our durable, non-woven disc with the efficient 3M™ Roloc™ quick-change attachment system
- ▶ An effective disc that cleans, finishes, blends and deburrs
- ▶ Conformable, non-woven disc combined with Roloc backing allows for aggressive cuttings
- ▶ Open-web construction resists loading and runs cool, allowing for consistent finishes

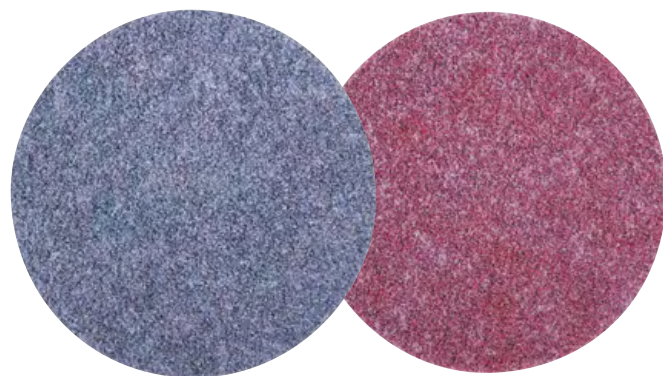
Scotch-Brite™ Roloc™ Surface Conditioning Disc (SC-DR)



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UPC	Diameter (inches)	Grade	Disc color	Max. speed (RPM)	Min./case
Roloc™ TS (plastic button) 					
048011-16508-0	1"	A CRS	Brown	30,000	200/cs
048011-16507-3	1"	A MED	Maroon	30,000	200/cs
048011-16506-6	1"	A VFN	Blue	30,000	200/cs
048011-16509-7	1"	S SFN	Gray	30,000	200/cs
048011-13249-5	1-1/2"	A CRS	Brown	30,000	50/200
048011-13250-1	1-1/2"	A MED	Maroon	30,000	50/200
048011-13251-8	1-1/2"	A VFN	Blue	30,000	50/200
048011-13253-2	2"	A CRS	Brown	25,000	50/200
048011-13254-9	2"	A MED	Maroon	25,000	50/200
048011-13255-6	2"	A VFN	Blue	25,000	50/200
048011-13256-3	2"	S SFN	Gray	25,000	50/200
048011-13257-0	3"	A CRS	Brown	18,000	25/100
048011-13258-7	3"	A MED	Maroon	18,000	25/100
048011-13259-4	3"	A VFN	Blue	18,000	25/100
048011-13260-0	3"	S SFN	Gray	18,000	25/100
048011-13261-7	4"	A CRS	Brown	12,000	25/100
048011-13262-4	4"	A MED	Maroon	12,000	25/100
048011-13263-1	4"	A VFN	Blue	12,000	25/100

Scotch-Brite™ Roloc™ Light Grinding and Blending Disc (GB-DR)



Super duty



Heavy duty

Feature:
Ceramic and aluminum oxide blend, durable edge, heat-resistant product construction

Backing:
Reinforced scrim

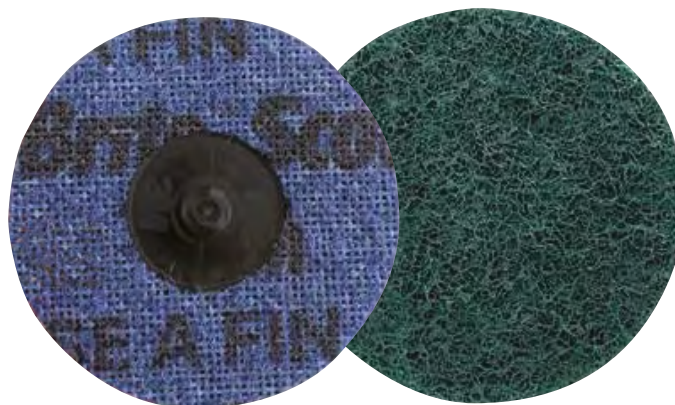
Application:
Light grind and blend in a single step

Substrate:
All metals

UPC	Diameter (inches)	Grade	Disc color	Max. speed (RPM)	Min./case
Roloc™ TR (plastic button) 					
048011-60355-1	2"	A CRS SD	Blue	25,000	50/200
048011-60354-4	2"	A CRS HD	Maroon	25,000	50/200
048011-60357-5	3"	A CRS SD	Blue	18,000	25/100
048011-60356-8	3"	A CRS HD	Maroon	18,000	25/100
048011-60359-9	4"	A CRS SD	Blue	12,000	25/100
048011-60358-2	4"	A CRS HD	Maroon	12,000	25/100
Roloc™ TSM (metal button) 					
048011-60375-9	2"	A CRS SD	Blue	25,000	50/200
048011-60374-2	2"	A CRS HD	Maroon	25,000	50/200
048011-60377-3	3"	A CRS SD	Blue	18,000	25/100
048011-60376-6	3"	A CRS HD	Maroon	18,000	25/100

- ▶ Scotch-Brite™ Roloc™ Light Grinding and Blending Discs are constructed with a ceramic abrasive grain blend to achieve light weld grinding and blending in mild-steel applications
- ▶ Light grinds and blends in a single step
- ▶ Disc backup pad helps provide high edge durability for consistent finishing and long disc life

Scotch-Brite™ Roloc™ Surface Conditioning Disc (SE-DR)




Feature:
Aluminum oxide, tough non-woven construction, strong edge, blue backing

Backing:
Non-woven construction

Application:
Deburr, refining, finishing and cleaning

Substrate:
All metals

UPC	Diameter (inches)	Grade	Disc color	Max. speed (RPM)	Min./case
Roloc™ TR (plastic button) 					
048011-18081-6	2"	A CRS	Brown	25,000	50/200
048011-18471-5	2"	A MED	Maroon	25,000	50/200
048011-30005-4	2"	A FIN	Green	25,000	50/200
048011-18082-3	3"	A CRS	Brown	18,000	25/100
048011-18472-2	3"	A MED	Maroon	18,000	25/100
048011-93453-2	3"	A FIN	Green	18,000	25/100

- ▶ Coarse, tough non-woven disc with a strong edge aggressively deburrs and finishes
- ▶ Open-web construction resists loading and runs cool, producing consistent finishes
- ▶ Conformable disc conditions surfaces without gouging, undercutting or damaging the base material

Choose your cut.

The Scotch-Brite™ Clean and Strip discs were designed with conformable, high-strength fibers that deliver quick and consistent performance. But each has its own unique place in your metalworking operations. Which one is right for you?

Scotch-Brite™ Clean and Strip Discs

XT Pro

- Rust, paint, light mill scale removal
- Maintains workpiece shape
- Low sparking
- Ideal for surface prep
- Made with silicon carbide mineral



XT Pro Extra Cut

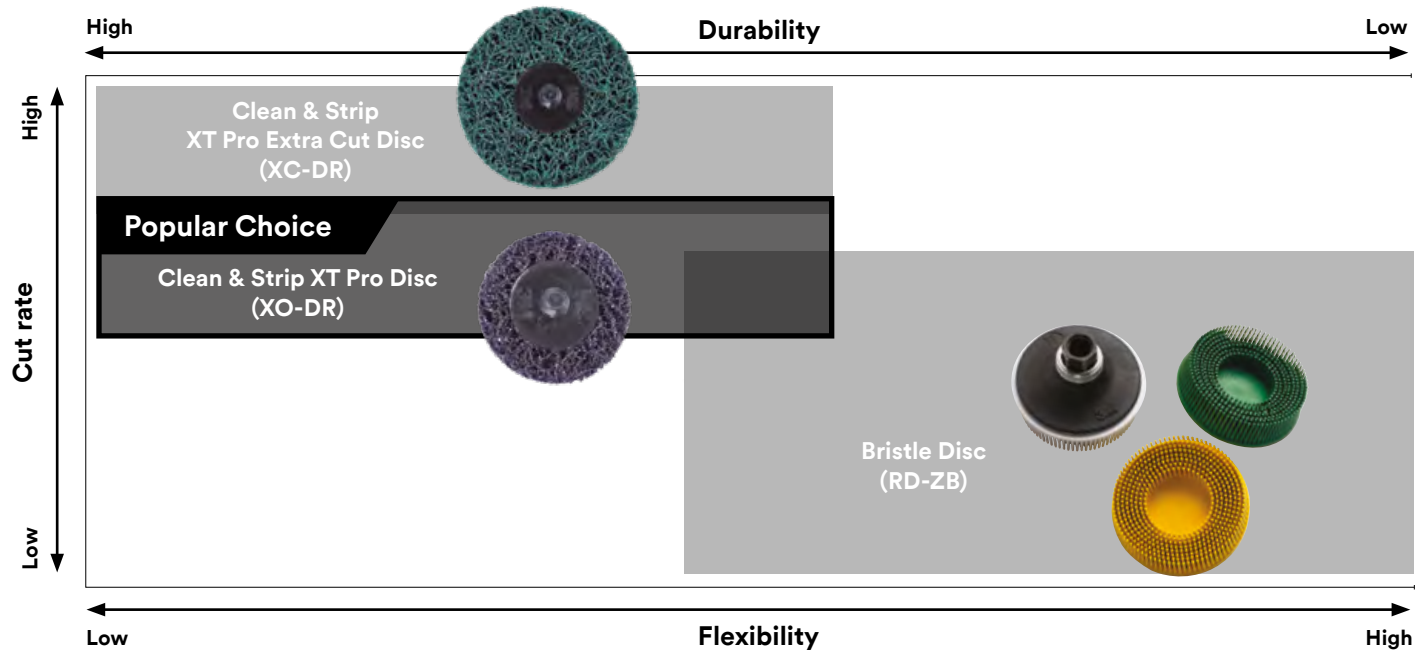
- Heavy rust and rust pit removal without leaving divots
- Thick paint and coating removal
- Weld refinement and removing weld discoloration
- Cuts to bare metal quickly
- Ideal for adhesion prep

BOTH

- Rapid coating removal and surface prep
- Decreased chunking – extended life
- Highly conformable
- High speed rating
- Quick-change, spin-on thread

Contamination removal and cleaning

Positioning | Contamination removal and cleaning



Product	Feature	Substrate	Application
Scotch-Brite™ Roloc™ Clean & Strip XT Pro Disc (XO-DR)	Durable, conformable, highly resistant to loading, low spark, silicon carbide	All metals	Coating removal; surface prep; rust, paint, and light mill scale removal
Scotch-Brite™ Roloc™ Clean & Strip XT Pro Extra Cut Disc (XC-DR)	Extended life, conformable, high speed rating, highly resistant to loading, aluminum oxide mineral, quick cut to bare metal, doesn't leave divots	All metals	Thick paint and coating removal; surface prep; heavy rust and rust pit removal; weld refinement; removing weld discoloration; adhesion prep
Scotch-Brite™ Roloc™ Bristle Disc (RD-ZB)	Ceramic and aluminum oxide blend, flexible bristles	All metals	Blending, finishing, polishing, cleaning

Scotch-Brite™ Roloc™ Clean & Strip XT Pro Disc (XO-DR)



Feature:

Durable, conformable, highly resistant to loading, low spark, silicon carbide

Backing:



Non-woven construction

Application:

Heavy contamination removal, rust, coatings, weld discoloration

Substrate:

All metals

UPC	Size dia. (inches) x ctr. hole	Grade	Disc color	Max. Speed (RPM)	Min./case
Roloc™ TR (plastic button) 					
638060-21538-8	2" x NH	S XCS	Purple	18,000	10/60
638060-21540-1	3" x NH	S XCS	Purple	15,000	10/cs
638060-21541-8	3" x NH	S XCS	Purple	15,000	10/40
638060-21542-5	4" x NH	S XCS	Purple	11,000	10/40
Roloc™ TR+ (plastic button) 					
638060-21552-4	4" x 1/2"	S XCS	Purple	12,000	10/cs
638060-21549-4	4" x 1"	S XCS	Purple	8,000	10/cs

- ▶ Load-resistant material resists clogging for consistent cutting action
- ▶ Quickly removes rust, paint, adhesives and other coatings
- ▶ Smear-resistant properties avoid extra cleaning of the work surface
- ▶ Extra coarse (XCS) grade silicon carbide provides aggressive cutting and leaves a fine finish without gouging the workpiece

Scotch-Brite™ Roloc™ Clean & Strip XT Pro Extra Cut Disc (XC-DR)



Feature:

Extended life, conformable, high speed rating, highly resistant to loading, quick cut to bare metal

Backing:


Non-woven construction

Application:

Rust removal, thick paint and coating removal, weld refinement, adhesion prep

Substrate:

All metals

UPC	Size dia. (inches) x ctr. hole	Grade	Disc color	Max. speed (RPM)	Min./case
Roloc™ TR (Plastic Button) 					
638060-21543-2	2" x NH	A XCS	Green	18,000	10/60
638060-21544-9	3" x NH	A XCS	Green	15,000	10/cs
638060-21545-6	3" x NH	A XCS	Green	15,000	10/40
638060-21546-3	4" x NH	A XCS	Green	11,000	10/40

- ▶ Removes heavy rust and rust pits without leaving divots
- ▶ Aluminum oxide provides a more aggressive cut versus Scotch-Brite™ Roloc™ Clean & Strip XT Pro
- ▶ Load-resistant material resists clogging for consistent cutting action
- ▶ Ideal for weld refinement and removing weld discoloration
- ▶ This unique disc can aggressively clean without significantly altering the base material

Scotch-Brite™ Roloc™ Bristle Disc (RD-ZB)



Feature:
Ceramic and aluminum oxide blend, flexible bristles

Backing:
Molded, flexible bristles

Application:
Strip, deburr, blend, finish, polish, clean

Substrate:
All metals



UPC	Size diameter (inches)	Grade	Disc color	Max. speed (RPM)	Min./case
Roloc™ TR (plastic button) 					
048011-18698-6	1"	50	Green	30,000	80/cs
048011-18706-8	1"	80	Yellow	30,000	80/cs
048011-18710-5	1"	120	White	30,000	20/80
048011-18730-3	2"	50	Green	25,000	10/40
048011-18732-7	2"	80	Yellow	25,000	10/40
048011-18733-4	2"	120	White	25,000	10/40
048011-18734-1	3"	50	Green	15,000	10/40
048011-18736-5	3"	80	Yellow	15,000	10/40
048011-18737-2	3"	120	White	15,000	10/40

- ▶ Our fast-running disc combines superior cutting action and increased ability to conform with the 3M™ Roloc™ quick change attachment system
- ▶ Efficiently clean, strip, deburr, blend, finish, polish, scratch and remove rust and coatings while maintaining the base product geometry
- ▶ For increased performance, Scotch-Brite™ Bristle Discs feature aluminum oxide blended with ceramic abrasive grain for one of the hardest, longest-lasting minerals available

3M™ Roloc™ + range

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Scotch-Brite™ Roloc™ + Flap Brush

Product overview:

- ▶ Produces a straight brushed finish on a variety of metals
- ▶ Suitable for cleaning and light deburring of various substrates
- ▶ Soft and conformable for uniform surface treatment without chatter marks



Description	UPC	Size (dia. x ctr. hole)	Grade
Scotch-Brite™ Roloc™+ Cut and Polish Flap Brush PF-ZR C&P FLP	00048011145884	3 in x 1-3/8 in	A MED
Scotch-Brite™ Roloc™ Finishing Flap Brush FF ZR	00048011147833	3 in x 1-3/8 in	S FIN

Scotch-Brite™ Roloc™ + Cut and Polish Disc

Product overview:

- ▶ The Scotch-Brite™ Roloc™+ Cut and Polish Disc is engineered to produce satin or high-luster finishes, cleaning or light deburring on a variety of metals
- ▶ Scotch-Brite Roloc+ Cut and Polish Disc is five discs of strong, durable cut and polish web that provides coverage on larger areas



Description	UPC	Size (dia. x ctr. hole)	Grade
Scotch-Brite™ Roloc™ Cut and Polish Disc C5-ZR S/B CPD5-R	00048011145907	4 in x 1-1/4 in	A MED

Scotch-Brite™ Roloc™ + Clean & Strip XT Pro and Scotch-Brite™ Roloc™ + Clean & Strip XT Pro Extra Cut

Product overview:

- ▶ Scotch-Brite™ Roloc™ + Clean & Strip Disc is an extra coarse grade, provides aggressive cleaning and leaves a fine finish while maintaining work piece geometry
- ▶ Coarse-grade silicon carbide provides aggressive cutting and leaves a fine finish without gouging the workpiece
- ▶ The new Scotch-Brite™ XT Pro and XT Pro Extra Cut discs provide improved comfortability and reduced chunking



Description	UPC	Size (dia. x ctr. hole)	Grade	Min./case
Scotch-Brite™ Roloc™ + Clean and Strip XT Pro Extra Cut Disc, TR+, 2-ply	00638060215548	4 in x 1 in	A XCS	10/cs
Scotch-Brite™ Roloc™ + Clean and Strip XT Pro Extra Cut Disc, TR+	00638060215555	4 in x 1/2 in	A XCS	10/cs
Scotch-Brite™ Roloc™ + Clean and Strip XT Pro Extra Cut Disc, TR+, Single Pack	00638060299173	4 in x 1/2 in	A XCS	10/cs
Scotch-Brite™ Roloc™ + Clean and Strip XT Pro Disc, TR+, 2-ply	00638060215494	4 in x 1/2 in	S XCS	10/cs
Scotch-Brite™ Roloc™ + Clean and Strip XT Pro Disc, TR+	00638060215524	4 in x 1/2 in	S XCS	10/cs
Scotch-Brite™ Roloc™ + Clean and Strip XT Pro Disc, TR+, Single Pack	00638060299111	4 in x 1 in	S XCS	10/cs

Roloc™ tools and accessories

3M™ Air-Powered Disc Sander

- ▶ Designed to allow greater access to work pieces compared to conventional larger disc attachments
- ▶ All models feature a powerful, high-torque air motor to optimize overall performance of the 3M™ Roloc™ System
- ▶ Easier handling, lightweight, compact design generates less vibration, while improving operator control
- ▶ 3M™ Greptile™ Gripping Material helps provide a more secure grip that can be held with less effort
- ▶ Works in combination with the 3M™ Roloc™ Quick Release System – discs lock securely in place with just half a twist
- ▶ All models are supplied with a 3M™ Roloc™ Rubber Back-Up Pad and 1/4" collet



28329/20231









28328/28341

UPC	Model	Tool diameter inch (mm)	Motor HP (W)	Max. speed (RPM)	Noise level dBA (power)	Weight pound (kg)	Length inch (mm)	Height inch (mm)	Air inlet thread	Airflow rate SCFM (LPM)	Collet size (inch)
051141-28341-8	28341	2 in (51)	0.3 (224)	20,000	81 (92)	1.1 (0.5)	6 (150)	3 (63)	1/4 in NPT	17 (481)	1/4 in
051141-28328-9	28328	2-3 in (51-76)	0.3 (224)	12,000	81 (92)	1.1 (0.5)	7 (172)	3 (64)	1/4 in NPT	17 (481)	1/4 in
051141-20231-0	20231	2 in (51)	0.5 (372)	20,000	89 (101)	1.3 (0.6)	7 (172)	3 (70)	1/4 in NPT	26 (736)	1/4 in
051141-28329-6	28329	2-3 in (51-76)	0.5 (372)	12,000	89 (101)	1.3 (0.6)	7 (172)	3 (70)	1/4 in NPT	26 (736)	1/4 in
051141-20232-7	20232	2-3 in (51-76)	1 (744)	15,000	84 (95)	2.0 (0.9)	8 (210)	3 (83)	3/8 in NPT	37 (1,048)	1/4 in

Accessories



Product	UPC	For use with:	Size/description	Hardness	Max. speed (RPM)	Qty./case
3M™ Roloc™ TR Disc Pads						
	051144-45101-2	 3M™ Roloc™ TR Discs	1" Diameter; 1/4–20 INT	Medium	30,000	5
	051144-45099-2		1-1/2" Diameter; 1/4–20 INT	Medium	30,000	5
	051144-45100-5		1-1/2" Diameter; 1/4–20 INT	Hard	30,000	5
	051144-45095-4		2" Diameter; 1/4–20 INT	Medium	25,000	5
	051144-45096-1		2" Diameter; 1/4–20 INT	Hard	25,000	5
	051144-45097-8		2" Diameter; 1/4–20 INT	Extra Hard	25,000	5
	051144-45092-3		3" Diameter; 1/4–20 INT	Medium	18,000	5
	051144-45091-6		3" Diameter; 1/4–20 INT	Hard	20,000	5
	051144-45093-0		3" Diameter; 1/4–20 INT	Extra Hard	20,000	5
	051144-45179-1		4" Diameter; 1/4–20 INT	Medium	12,000	5
	051141-28474-3		4" Diameter; 3/8–24 INT	Hard	12,000	5
	051141-28475-0		4" Diameter; 3/8–24 INT	Extra Hard	12,000	5
	051144-83242-2		4" Diameter; 5/8–11 INT	Medium	12,000	5
	051144-83489-1		4" Diameter; 5/8–11 INT	Hard	12,000	5
051144-83980-3	4" Diameter; 5/8–11 INT	Extra Hard	12,000	5		
3M™ Roloc™ Cool Running Disc Pads						
	051144-82974-3	 3M™ Roloc™ TR Discs	2" Diameter; 1/4–20 INT	Medium	20,000	5
	051141-28711-9		2" Diameter; 1/4–20 INT	Hard	20,000	5
	051144-82975-0		3" Diameter; 1/4–20 INT	Medium	12,000	5
	051141-28710-2		3" Diameter; 1/4–20 INT	Hard	12,000	5
	051111-56479-0		4" Diameter; 3/8–24 INT	Hard	15,000	5
	051141-28473-6		4" Diameter; 5/8–11 INT	Hard	15,000	5
3M™ Roloc™ TS or TSM Disc Pads						
	051144-77729-7	 3M™ Roloc™ TSM Discs and "Screw on" Abrasive Discs	1-1/2" Diameter; 1/4–20 INT	Medium	30,000	5
	051144-77728-0		1-1/2" Diameter; 1/4–20 INT	Hard	30,000	5
	051144-14211-8		2" Diameter; 1/4–20 INT	Medium	25,000	5
	051144-14212-5		2" Diameter; 1/4–20 INT	Hard	25,000	5
	051144-14215-6		3" Diameter; 1/4–20 INT	Medium	18,000	5
	051144-14216-3		3" Diameter; 1/4–20 INT	Hard	20,000	5
	051141-28578-8		4" Diameter; 5/8–11 INT	Hard	12,000	5

Safety Information

3M™ Coated Abrasive Roloc™ and Scotch-Brite™ Roloc™ / Roloc™ + / Spindle Mount Products



Read this insert before mounting or using product. Follow tool's instructions, employer's safety rules, ANSI B71 re: Use, Care, and Protection of Abrasive Wheels, and any other local standards. Operator must be properly trained.



Improper operation can cause serious injury or death to operators and bystanders. Sparks, heat, and dust generated while grinding can create fire, explosion, and respiratory hazards.

Planning and Preparation

Prepare a safe work area

Check workpiece materials

Use only on Carbon Steel, Stainless Steel, Cast Iron, or Alloys of Titanium, Copper, Zinc, Chromium/Nickel, or Aluminum to reduce the risk of disc breaking, fire, explosion, or health hazards. Read the Safety Data Sheets (SDSs) for the workpiece materials.

Respiratory hazard

Exposure to dust generated from workpiece and/or abrasive materials can result in serious, permanent lung damage or other injury. To reduce this risk:

- ▶ Use dust capture or local exhaust as appropriate.
- ▶ Wear all recommended protective equipment.

Fire and explosion hazard

Grinding produces sparks and heat. Keep away from anything that can ignite or explode. Do not allow dust to accumulate. Do not use on flammable or explosive materials.

Do not allow bystanders

Keep bystanders out of the work area. Disc fragments can be thrown a long distance, and bystanders may also be exposed to respiratory, fire, and explosion hazards. If other people must be nearby, ensure that they wear proper personal protective equipment (PPE). Always wear proper PPE as identified by your risk assessment to help protect against dust, grinding sparks and debris, noise, and some disc fragments:



▶ full face shield



▶ gloves



▶ impact resistant protective eyewear marked as ANSI Z87.1 conformant
▶ hearing protection
▶ NIOSH approved respirator



▶ body and skin protection

Do not alter or modify the disc in any way.



Safe Operating Procedures

Tool selection:

1. Use only on tools designed for discs.
2. Compare the maximum operating speed (RPM) rating of the tool with the maximum RPM rating of the backup pad and disc. Make sure the machine speed does not exceed the maximum operating speed marked on the product or package (see example on this page). **Exceeding product's Max. RPM can cause it to break apart and cause serious injury.**

Mounting:

1. Inspect the backup pad and disc. Replace if damaged or worn out (e.g., cracks or chips). **Damaged or worn out backup pads or discs can break apart during use and cause serious injury.**
2. Follow tool manufacturer's mounting instructions. Always use proper backup pad with discs. Select a backup pad that is compatible with and the same size as, disc being used.
3. Never force disc onto tool spindle. Do not alter disc in any way.
4. Use correct attachment system. Ensure the backup pad shaft is fully seated to the tool per manufacturer recommendation.

Operation:

1. Direct disc away from your body and bring it up to operating speed before grinding.
2. If vibration or wobbling occurs, stop immediately. Determine the cause and correct before continuing. Vibration or wobbling can be caused by:
 - ▶ Worn or damaged backup pad or disc
 - ▶ Stripped threads on mandrel
3. Follow good grinding practices:
 - ▶ Secure workpiece.
 - ▶ Keep all body parts and objects clear of grinding path.
 - ▶ Grind with product 5-10 degrees from workpiece.
 - ▶ Begin grinding by gradually engaging workpiece
 - ▶ Never bump or force disc so that tool motor slows or stalls.
 - ▶ Direct sparks away from face and body.
 - ▶ Product that disengages from the backup pad may cause injury. Abruptly stopping tool off work piece can cause the product to disengage from the backup pad. Do not abruptly stop the product off the workpiece.
 - ▶ Do not use discs with abnormally curled or cupped shape.

Example

Roloc™ Backup Pad
Max. RPM = 20,000

Product
Max. RPM = 18,000

In this example, do not exceed 18,000 rpm





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